

What is claimed is :

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1. An inflatable bladder comprising;
an elastomeric material having an outer surface, wherein at least a portion of said outer surface comprises an anti-tack rubber, said anti-tack rubber containing a blend of a first rubber and an anti-tack composition,
5 wherein said anti-tack rubber has suitable curing and anti-tack properties for use with an apparatus for manufacturing pneumatic tires.
 2. An inflatable bladder according to claim 1, wherein said first rubber contains a natural rubber, and said anti-tack composition contains a chlorosulfonated polyethylene.
 3. An inflatable bladder according to claim 1, wherein said first rubber contains a synthetic rubber, and said anti-tack material contains a chlorosulfonated polyethylene.
 4. An inflatable bladder according to claim 2, wherein said anti-tack rubber forms a separate first ply, said first ply adhered to said outer surface of said elastomeric material, wherein said first ply has suitable curing and anti-tack properties for use with said elastomeric material in manufacturing
5 pneumatic tires.
 5. An inflatable bladder according to claim 3, wherein said anti-tack rubber forms a separate first ply, said first ply adhered to said outer surface of said elastomeric material, wherein said first ply has suitable curing and anti-tack properties for use with said elastomeric material in manufacturing pneumatic tires

6. A method to make an inflatable bladder with suitable curing and anti-tack properties for use with an apparatus for manufacturing pneumatic tires comprising the steps of:

5 mixing at least a first rubber and a anti-tack composition to form a mixture, said mixture forming an anti-tack rubber having suitable curing and anti-tack properties for use with the inflatable bladder in manufacturing pneumatic tires;

forming said anti-tack rubber into a first ply; and

10 adhering said first ply to an elastomeric material, wherein said elastomeric material forms a second ply of the inflatable bladder.

7. A method according to claim 6, wherein said adhering step comprises adhering said first ply to said second ply by use of an autoclave.

8. An anti-tack rubber which comprises:
a first rubber; a chlorosulfonated polyethylene; an accelerator; a plasticizer; and metal oxides.

9. An anti-tack rubber according to claim 8, wherein said anti-tack rubber has suitable curing and anti-tack properties for use with an inflatable bladder in manufacturing pneumatic tires.

10. An anti-tack rubber according to claims 9, wherein said metal oxides further comprise; magnesium oxide, zinc oxide; and titanium dioxide.

11. An anti-tack rubber according to claims 9, wherein said accelerator is a benzothiazyl disulfide; and said plasticizer is a phenylenediamine.

12. An anti-tack rubber according to claims 10, wherein said accelerator is a benzothiazyl disulfide; and said plasticizer is a phenylenediamine.
13. A method to make an anti-tack rubber which comprises:
combining a first rubber and a chlorosulfonated polyethylene to form a mix;
adding fillers, reinforcing agents, processing aids, and plasticizers to
5 said mix;
blending into said mix cross-linking agents, metal oxides, cure accelerators, and cure activators to form said anti-tack rubber with suitable curing properties for use with an inflatable bladder in manufacturing pneumatic tires; and
10 forming said anti-tack rubber into a separate workable ply
14. A method to use an inflatable bladder with an apparatus for manufacturing pneumatic tires comprising the steps of:
inflating the bladder having an anti-tack rubber;
contacting a rubber tire material in manufacturing a pneumatic tire with
5 the bladder, and
deflating the bladder, wherein the bladder has suitable cure and anti-tack properties so as to release from contact with said rubber tire material upon deflation.
15. A method according to claim 14, wherein said anti-tack rubber contains a blend of a first rubber and an anti-tack composition.
16. A method according to claim 15, wherein the inflatable bladder comprises an anti-tack rubber ply.

17. A method to use an inflatable bladder for turning tire plies over a bead ring comprising cycles of;

wrapping tire plies on a tire building drum;

positioning bead rings on said tire building drum;

5 inflating the bladder to turn said tire plies over said bead rings; and

deflating said bladder, wherein said bladder contains an anti-tack rubber with suitable cure properties so as to release from said tire plies upon repeated deflation cycles.

18. A method according to claim 17, wherein said anti-tack rubber contains a blend of a first rubber and an anti-tack composition.

19. A method according to claim 18, wherein said inflatable bladder comprises an anti-tack rubber ply.

20. A method according to claim 18, wherein the inflating cycle comprises a first inflatable bladder, and a second inflatable bladder, wherein said first inflatable bladder contains an anti-tack rubber with suitable cure properties so as to release from said tire plies upon repeated deflation cycles, and wherein
5 said second inflatable bladder inflates to further turn said tire plies up over said bead.

21. A method according to claim 20, wherein said anti-tack rubber contains a blend of a first rubber and an anti-tack composition.

22. A method according to claim 21, wherein said first inflatable bladder comprises an anti-tack rubber ply.